

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009419**Date Inspected:** 26-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua/Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

This QA inspector observed the following work in progress:

Segment 8AW

SMAW welding of weld joint Seg043E-041, 042, 050, 051, 014, 015, 032, 033, 023, 024 located on Segment 8AW. Welder is identified as 037942 (4F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint Seg043E-027, 036 located on Segment 8AW. Welder is identified as 044772 (3G). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM.

FCAW repair welding of weld joint SSD11A-PP063-181 located on Segment 8AW. Welder is identified as 066683 (2G/2F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G(2F)-FCM-Repair.

FCAW repair welding of weld joint SSD10A-PP062-092 located on Segment 8AW. Welder is identified as 066683 (2G/2F). ZPMC QC is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-FCAW-2G(2F)-FCM-Repair.

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Segment 11EE

SAW welding of weld joint Seg074A-009 located on Segment 11EE. Welder is identified as 044780(1G). ZPMC QC is identified as Zhang Xian Ji. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

Segment 11CW

SAW welding of weld joint Seg069A-006 located on Segment 11CW. Welder is identified as 044771 (1G). ZPMC QC is identified as Tang Yu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint Seg67A-004 located on Segment 11BW. Welder is identified as 050988 (1G). ZPMC QC is identified as Tang Yu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

Segment 8AE

FCAW welding of weld joint Seg044F-001, 002 located on Segment 8AE. Welder is identified as 055564(2F/3F). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-3 and WPS-B-T-2133.

SMAW welding of weld joint Seg044G-002, 006 located on Segment 8AE. Welder is identified as 204339 (2F). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

SMAW welding of weld joint Seg044G-005, 008 located on Segment 8AE. Welder is identified as 204339 (2F). ZPMC QC is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel, Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
